

Date: Wednesday, 03/09/2008 10:40:28 AM
 *User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	41773A		
Estimate Number :	10853		
P.O. Number :		Part Number :	D3325041
This Issue :	03/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3325 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	41286A	Drawing Revision :	B
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/09/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>5008.9.03</u>		
Comment :	Est Rev:A 05.02.09 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33281	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number	Description	Batch
2 D3328-1	Hinge Plate	B 33871

SY 08/11/05

2.0	D33491	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number	Description	Batch
2 D3349-1	Spacer Bushing	B 34205

SY 08/11/05

3.0	D33521	Label Plate
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty Part Number	Description	Batch
2 D3352-1	Label Plate	B 41925

SY 08/11/05

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number	Description	Batch
2 D3367-1	Mounting Bracket	B 40775

SY 08/11/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .500 x .500 x .035w



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

SAD

08/10/28

0

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	M109191
3	D3325-3	Interior Tube	M109191
2	D3325-5	Full Lengh Tube	M109191

SAD

08/11/29

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
A/R4130 Steel Rod M100075

4-Deburr as required

SAD

08/11/06

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/11

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/11 ①

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109152.

1ST COAT

START TIME:

1:00

OVEN TEMPERATURE:

400°

FL

08/11/11

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 41773A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

1:30

2ND COAT:

START TIME:

1:55

OVEN TEMPERATURE:

400°

FINISH TIME:

2:25

FD 08/11/11 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/10/12

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PM 41773

8/10/12 (1)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13

Job Completion



MF 08-11-12

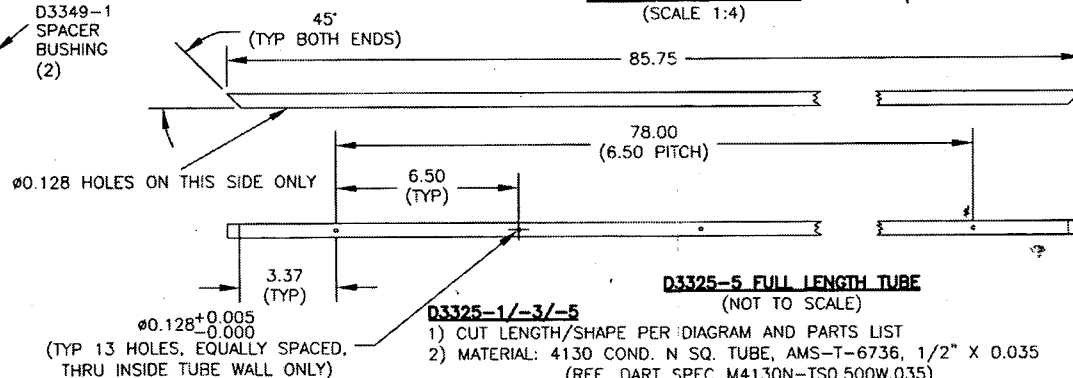
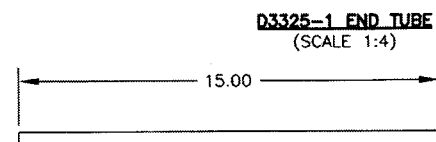
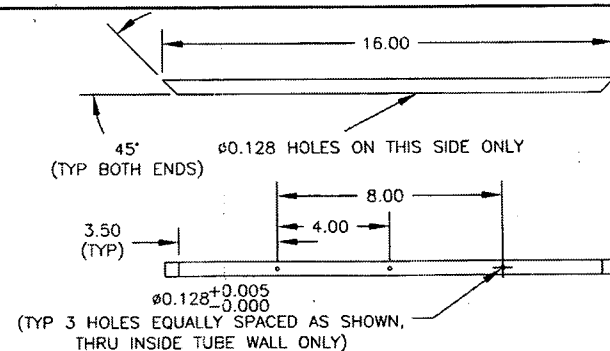
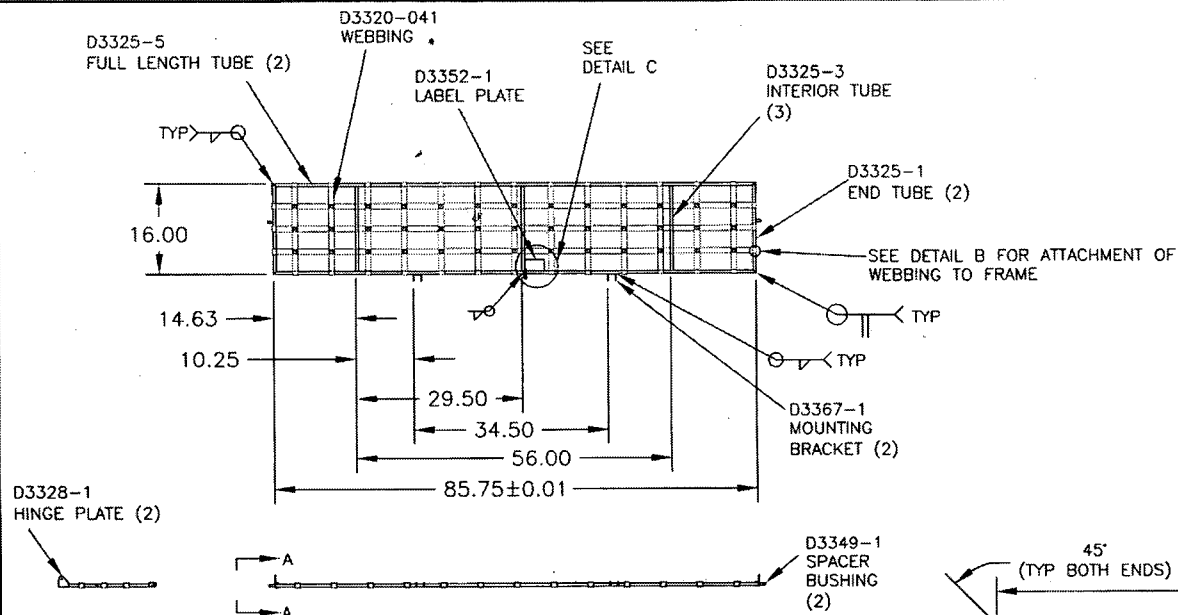
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20606AD4W3	32	RIVET
AN960JD9	32	WASHER

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DH	DRAWN BY
CHECKED	PH	APPROVED
DATE	05.04.25	
DART	DART AEROSPACE LTD.	
DRAWING NO.	D3325	REV. B
TITLE	BASKET LID ASSEMBLY	SHEET 1 OF 3
SCALE		1:20

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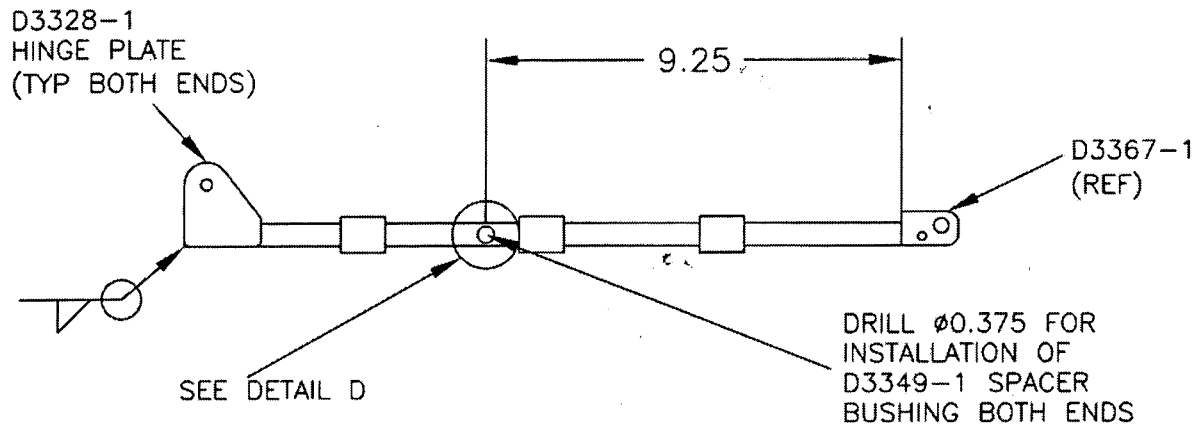
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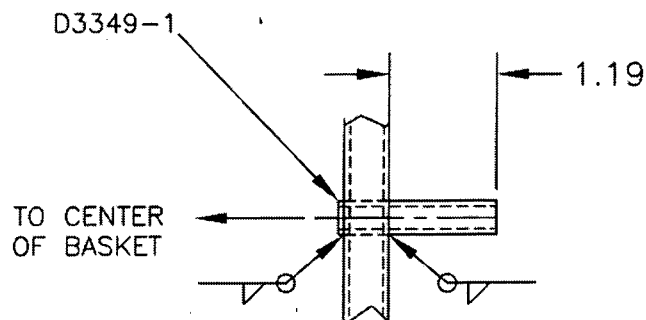
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DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4



VIEW A-A



DETAIL D
(SCALE 1:2)

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05.04.29 [Signature]

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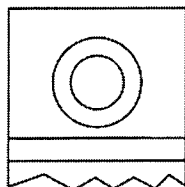
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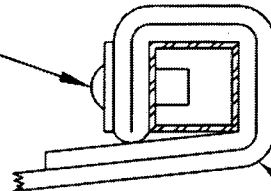
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CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

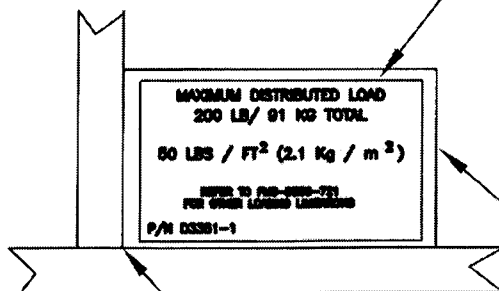


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28 PH

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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